Concepts for Drying, Debinding and Sintering of Parts with Binder Content

**Process**

**Atmosphere**

**Maximum Temperature for Debinding**

- 300 °C
- 450 °C
- 450 °C
- 600 °C

**Organic Quantity**

- Organic quantity low
- Organic quantity low
- Organic quantity low
- Organic quantity medium

**Requirement**

- Low requirement for temperature uniformity
- Increased requirement for temperature uniformity
- Increased requirement for temperature uniformity
- Low requirement for temperature uniformity

**Concept**

- LS
- LS
- DB10
- BO

- Acc. to EN 1539 Type A. Monitored air exchange. Exhaust gas venting via nozzles in the on-site extraction system.
- Acc. to EN 1539 Type A (NFPA 86 Class A). Monitored air exchange. Active venting of the exhaust gas via integrated exhaust gas fan.
- Monitored air exchange. Active venting of the exhaust gas via integrated exhaust gas fan. Uncontrolled furnace underpressure.
- Debinding process with control difficulties of heating ramp (exothermic reaction).

**Furnace Type**

- KTR, page 62
- NA .. LS, page 60
- NA .. 45 DB10, page 42
- L .. BO, page 56
- HT .. DB, page 58

**Post-Treatment of Exhaust Gases**

- Integrated thermal afterburning/catalytic afterburning

**Furnace Heating**

- Electric
- Gas

1) Air
2) Protective gas